

ASAP TODAY

Work Order ID 54576

December 14, 2009 10:45:10 AM

Page 1

Item ID: D2324

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 14/12/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 09-12-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2324

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2324.

SB 10/01/15

10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8.0/01/15

710

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:00

OVEN TEMPERATURE:

FINISH TIME:

1:30

320°

= 7 m.k

10/01/15

10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 54576**

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Page 2

Item ID: D2324

Accept



Setup Start



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Item Name: Strut

Start Date: 14/12/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

C 14/01/15 (10)

140 Identify as per dwg &amp; Stock Location: 51

0.00



Packaging

Memo

0.00

Packaging

C 14/01/15 (10)

150 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15  
ME 10-1-15

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

December 14, 2009 10:45:16 AM

Page 1

Work Order ID: 54576

Parent Item: D2324

Parent Item Name: Strut


Start Date: 14/12/2009

Required Date: 18/12/2009

Comments:


Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-12A 		Purchased	No			100	Each	127.0000	20.0000			
Bolt												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
106605	23	
109297	4	
112720	100	

8 10/01/15  
20

AN960JD10 		Purchased	No			100	Each	1,862.0000	40.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1862	
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	64	
112314	534	
112369	22	
113149	1000	

8 10/01/15  
40

D2324-3 		Manufactured	No			100	Each	0.0000	10.0000			
Bar												

B 54709

10 8 10/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 54576



Parent Item: D2324



Parent Item Name: Strut

Start Date: 14/12/2009

Required Date: 18/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg* Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	#Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2324-5		Manufactured	No			100	Each	46.0000	20.0000			

Strap

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

BS2461

7

ST

14

39638

13

46324

1

Main Warehouse

ST24

32

52661

32

MS21042L3

Purchased

No

100

Each

2,640.000 20.0000



Nut

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

ST

2640

110844

32

111274

31

111668

156

112314

1921

112385

500

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

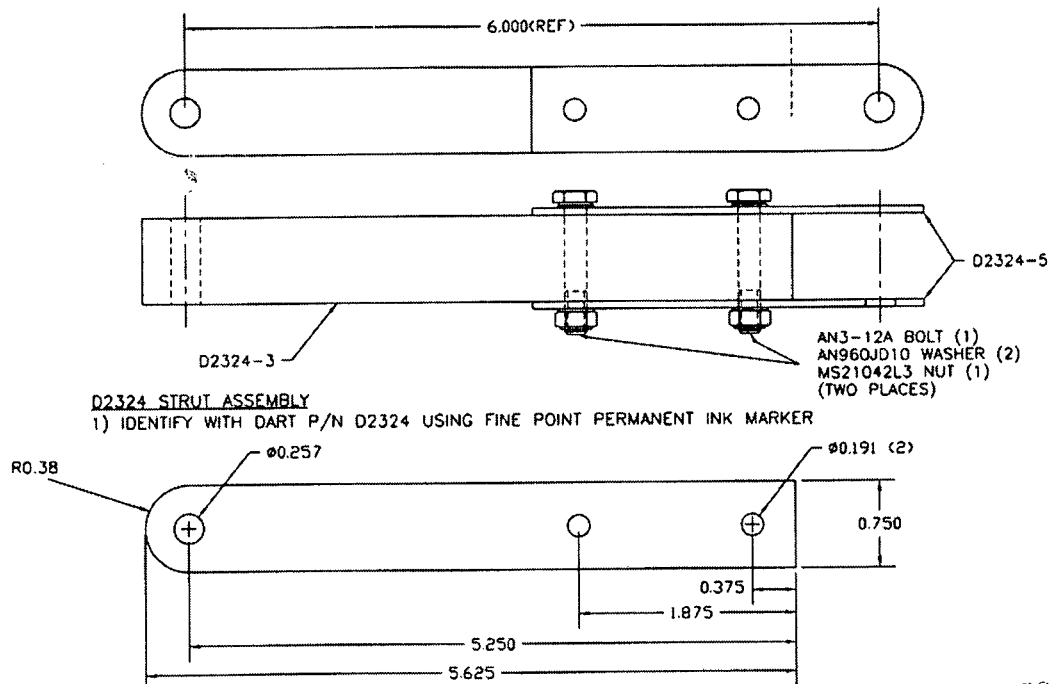
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**DART**

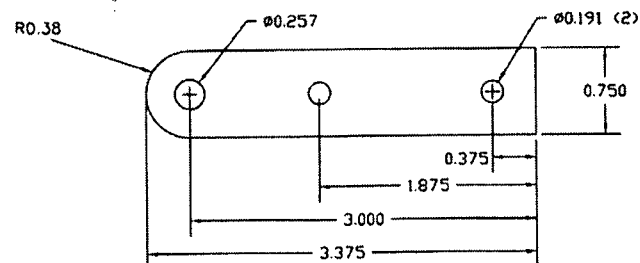
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 561576

*AP 04/12-14*

W/O:		WORK ORDER CHANGES					
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